



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

C45-K

Job Sheet 172246



Part No: C45-K

Job Qty: 1 ea

Part Name: C-Series Remote Hook 4,500 lbs Lift Capacity - Keeperless



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/14/18

Job Tracking No:

Due Date: 2/28/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: C45-K REV.2 IPP REV:A 18.02.07 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		2/27/18	0.00	0.00	Start Up Small Fab-1		SB
100	Small Fab	1 pcs		2/28/18	0.00	0.50	Small Fab-9		AP
120	QC	1 pcs		2/28/18	0.00	0.00	QC5		SB
140	Packaging	1 pcs		2/28/18	0.00	0.00	Packaging3-1		
160	QC21-SA	1 Ea		2/28/18	0.00	0.00	QC21		ma 18/03/18

Part Op 100 - 1- PICK C45-2-1 AND LASER ENGRAVE AS PER DWG. SEE NOTE 3 AND 4 ON SHEET 3. 2- ASSEMBLE AS
Descriptions: PER DWG 3- PERFORM ALL NECESSARY TEST USING FAI TEST SHEET.

LOCTITE 62040 → 138788 / SAF-T-EZE MGBT-16 → M128063

DAB
21
3-20

MAR 13 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
188-FPSS-1/4-20-3/8	Set Screw	2 Ea (2 ea)	90-Start up Operation	5048557
188-FSCS-1032-5/8	Wire Clamp Screw	4 Ea (4 ea)	100-Small Fab	5031242
2595K2	Heat Shrink	1 ft (1 ea)	100-Small Fab	5042977
32448	16-14 AWG Knife Connector	2 Ea (2 ea)	100-Small Fab	5044617
600-1309-A	Label	1 Ea (1 ea)	100-Small Fab	5028572
600-1312	Caution Sticker	1 (1 ea)	100-Small Fab	5029482
AN4-23A	Bolt	2 Ea (2 ea)	100-Small Fab	FM127951-2
AN5-21A	Bolt	4 Ea (4 ea)	100-Small Fab	FM134740-0
C10-41	Stain Relief Connector	1 Ea (1 ea)	100-Small Fab	5040663
C2-14-2	Label Rivets	2 Ea (2 ea)	100-Small Fab	5040661
C45-1-1	Manual Knob Release	1 Ea (1 ea)	100-Small Fab	5029295
C45-10-1	Spring Pin	1 Ea (1 ea)	100-Small Fab	5040658
C45-10-2	Lock Spring	1 Ea (1 ea)	100-Small Fab	5048643
C45-11-1	Side Plate Solenoid	1 Ea (1 ea)	100-Small Fab	5029296
C45-11-2	Locating Pin	2 Ea (2 ea)	100-Small Fab	5040659
C45-12-1	Lock Bushing	2 Ea (2 ea)	100-Small Fab	5029298
C45-12-2	Lock Shaft	1 Ea (1 ea)	100-Small Fab	5046506
C45-12-3	Lock	1 Ea (1 ea)	100-Small Fab	5029300
C45-12-4	Lock Roller	1 Ea (1 ea)	100-Small Fab	5029301
C45-12-5	Lock Roller Pin	1 (1 ea)	100-Small Fab	5029302
C45-12-6	Retaining Ring	2 (2 ea)	100-Small Fab	5045011
C45-13-1	Keeper Bushing	2 Ea (2 ea)	100-Small Fab	5029304
C45-13-3	Keeper Shaft	1 Ea (1 ea)	100-Small Fab	5029304
C45-15	Keeperless Adapter	1 (1 ea)	100-Small Fab	5029309

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐												
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Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com Container No: S042382 Part: C45-K Serial No/Batch: S042382 Revision: C45-K Inspector:				Completed By																												
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C45-2-1	Sideplate - MRK	1 Ea (1 ea)	100-Small Fab	5029313
C45-3-1	Radial Bearing	2 (2 ea)	100-Small Fab	5029314
C45-3-10	Latch Shaft	1 Ea (1 ea)	100-Small Fab	5041144
C45-3-11	Actuator	1 Ea (1 ea)	100-Small Fab	5042953
C45-3-12	DU Bearing	1 (1 ea)	100-Small Fab	5045017
C45-3-2	Latch Roller Pin	1 (1 ea)	100-Small Fab	5029316
C45-3-2-1	Snap Ring	2 (2 ea)	100-Small Fab	5045017
C45-3-3	Latch Roller	1 Ea (1 ea)	100-Small Fab	5029318
C45-3-4	Pin	2 Ea (2 ea)	100-Small Fab	5025992
C45-3-4-ALL	Retaining Ring	4 Ea (4 ea)	100-Small Fab	5035997
C45-3-5	Spacer	2 Ea (2 ea)	100-Small Fab	5027245
C45-3-6	Latch	1 Ea (1 ea)	100-Small Fab	5043637
C45-3-7	Link	1 (1 ea)	100-Small Fab	5029322
C45-3-8A	Actuator Shaft Bushing	1 Ea (1 ea)	100-Small Fab	5029323
C45-3-8B	Actuator Shaft Bushing	1 Ea (1 ea)	100-Small Fab	5029324
C45-3-9	Lever Spring	1 (1 ea)	100-Small Fab	5029325
C45-4-1	Trunnion Bushing	2 Ea (2 ea)	100-Small Fab	5046023
C45-4-4A	C45 Load Beam Assembly	1 Ea (1 ea)	100-Small Fab	5029327
C45-4-4KA	Load Beam Keeperless Assembly	1 Ea (1 ea)	100-Small Fab	5048114
C45-4-5	Loadbeam Spacer	1 Ea (1 ea)	100-Small Fab	5043615
C45-5-1	Lever Stop Pin	1 Ea (1 ea)	100-Small Fab	5040657
C45-5-2	Lever Stop	1 (1 ea)	100-Small Fab	5029330
C45-7-1	LOADBEAM BUMPER	1 Ea (1 ea)	100-Small Fab	5029332
C45-7-2	Lock Bumper	2 Ea (2 ea)	100-Small Fab	5029333
C45-8-1-2	Solenoid Nut	2 Ea (2 ea)	100-Small Fab	5029334
C45-8-2 (H-2553-020)	Solenoid	1 Ea (1 ea)	100-Small Fab	5040265
C45-8-4	Solenoid Cover Gasket	1 (1 ea)	100-Small Fab	5029336
C45-8-5	Solenoid Cover	1 Ea (1 ea)	100-Small Fab	5041616
C45-9-1	Clock Spring Cover	1 (1 ea)	100-Small Fab	5029337
C45-9-2	Clock Spring	1 (1 ea)	100-Small Fab	
EL-PLUG-M	3-Prong Male Spade Plug	1 Ea (1 ea)	100-Small Fab	5031224
EL314-SJTOW	3 Wire	1 ft (1 ea)	100-Small Fab	5029542
MS21044N5	Nut	4 Ea (4 ea)	100-Small Fab	FM129624-40
MS27039-4-08	Screw	1 Ea (1 ea)	100-Small Fab	5039330
NAS1149F0563P	Washer	8 Ea (8 ea)	100-Small Fab	M138170
NAS1149F0032P	Washer	3 Ea (3 ea)	100-Small Fab	M127832-254-4-48
C45-12-1	SPRING Pin (92383A695)	1		5040831

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	188-FPSS-1/4-20-3/8	2	88	0
100-Small Fab	188-FSCS-1032-5/8	4	188	0
	2595K2	1	0	0
	32448	2	197	0
	600.1309-A	1	0	0
	600.1312	1	0	0
	AN4-23A	2	628	0
	AN5-21A	4	45	0
	C10-41	1	20	0
	C2-14-2	2	200	0
	C45-1-1	1	0	0
	C45-10-1	1	100	0
	C45-10-2	1	0	0
	C45-11-1	1	0	0
	C45-11-2	2	20	0
	C45-12-1	2	0	0
	C45-12-2	1	0	0
	C45-12-3	1	0	0
	C45-12-4	1	0	0
	C45-12-5	1	0	0
	C45-12-6	2	0	0
	C45-13-1	2	0	0
	C45-13-3	1	0	0
	C45-15	1	0	0
	C45-2-1	1	0	0
	C45-3-1	2	0	0
	C45-3-10	1	20	0

DQA: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval				
Description Work Order Deviation				Disposition							
• NO LASER ENGRAVE, USED 600-1309A + 600-1312 REPLACE AN423A ^{BY} FOR AN422A/SO41126 REPLACE NAB1149F0632P ^{BY} FOR NAS1149F0463P								Completed By			
								Lead hand / Supervisor Approval Verification			
								QC / QA Coordinator Approval			
Root Cause				FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
				OTHER :							

C45-3-11	1	0	0
C45-3-12	1	0	0
C45-3-2	1	0	0
C45-3-2-1	2	0	0
C45-3-3	1	0	0
C45-3-4	2	0	0
C45-3-4-1	4	100	0
C45-3-5	2	98	0
C45-3-6	1	1	0
C45-3-7	1	0	0
C45-3-8A	1	0	0
C45-3-8B	1	0	0
C45-3-9	1	0	0
C45-4-1	2	0	0
C45-4-4A	1	0	0
C45-4-4KA	1	0	0
C45-4-5	1	0	0
C45-5-1	1	25	0
C45-5-2	1	0	0
C45-7-1	1	0	0
C45-7-2	2	0	0
C45-8-1-2	2	0	0
C45-8-2	1	0	0
C45-8-4	1	0	0
C45-8-5	1	5	0
C45-9-1	1	0	0
C45-9-2	1	0	0
EL-PLUG-M	1	36	0
EL314-SJTOW	1	248	0
MS21044N5	4	39	0
MS27039-4-08	1	98	0
NAS1149F0563P	8	233	0
NAS1149F0632P	3	36	0

Part Specifications

Specifications could not be found.

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OTHER : _____					



Remote Cargo Hook Test Form

C45-K

Work Order 172246

Customer _____

Serial Number S042382

Date 2018/03/08

# of Releases	Load (Lbs.)	Release Method	Remarks	Result	Pass/fail
1	11,250	Static Hold	Hold for two Minutes and reduce load to zero	N/A	PASS
10	2,250	Electircal, 25 volts	No "hang ups" permitted	N/A	PASS
2	4,500	Electircal, 22 volts	Current shall not exceed 12.4A	9.2 A	PASS
2	3,500	Electircal, 22 volts	Current shall not exceed 12.4A	9.0 A	PASS
2	2,500	Electircal, 22 volts	Current shall not exceed 12.4A	9.0 A	PASS
2	1,500	Electircal, 22 volts	Current shall not exceed 12.4A	9.0 A	PASS
2	500	Electircal, 22 volts	Current shall not exceed 12.4A	9.0 A	PASS
1	4,500	Electircal, 20 volts	Current shall not exceed 11.3A	8.5 A	PASS
1	4,500	Electircal, 28 volts	Current shall not exceed 15.8A	11.7 A	PASS
1	4,500	Manual		N/A	PASS
1	4,500	Impact Test	Impact shackle 10 times, shall not release	N/A	PASS
1	N/A	Solenoid Ohms	Shall not exceed 1.7-2.0 Ohms	2.0 Ohms	PASS
1	N/A	Electircal Continuity	Across both wires	N/A	PASS

Test Conducted By:

ALAIN PATRY

Technician

Submit

Signature:

Director Of Quality Assurance

DAS
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9-89